Work Order ID 74518

Monday, October 03, 2011 4:01:16 PM

Item ID: D3566-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Gasket

Start Date: 9/30/2011 **Start Qty:** 16.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 16.00 **Customer:**

Reference:

Approvals: **Process Plan:** M.L.J **Date:** 11/10/03 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3566	Rev C								
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				B11-10-11			
FLOW CNC Waterjet	1-Cut as per Dwg D3566 ☐Dwg Rev: C ☐Prog Rev: C ☐2-Deburr if necessary							26	
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				B11-10-11			
Quality Control									
120	QC8- Inspect parts - second check	0.00				counted			
QC	**Memo**	0.00 S 11/10/12				26			
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: FP	0.00							
Packaging	**Memo**	0.00					11/10/12		2C
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00					11/10/12		
QC	**Memo**	0.00							
Quality Control									

MF 11-10-12

Dart Aerospace Ltd

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Picklist Print

Monday, October 03, 2011 4:01:22 PM

Work Order ID: 74518

Parent Item: D3566-1

Parent Item Name: Gasket

Start Date: 9/30/2011 **Required Date:** 10/14/2011

Start Qty: 16.00 **Required Qty:** 16.00

Comments:
IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	636.8500	0.911	16.19556	24 BI 11-10-11		

Location	Loc Qty	Loc Code
MAT052	636.85	
117295	55.68	
118026	127.87	
118663	73.3	
119130	380	119130

26

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	74518
Description: Gasket	**Part Number:**	**D3566-1**
Inspection Dwg: D3566 **Rev:** C		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.098	x		V IB02	
18.00	+/-0.030	18.00	x		T IB01	
12.10	+/-0.030	12.10	x		T	
2.43	+/-0.030	2.435	x		V	
6.00	+/-0.030	6.00	x		T	
1.40	+/-0.030	1.40	x		V	
0.30	+/-0.030	.306	x		V	
0.30	+/-0.030	.303	x		V	
0.063	+/-0.010	.060	x		V	
Ø0.188	+0.005/-0.001	.193	x		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-10-11	Date:	11/10/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DD	

Dart Aerospace Ltd

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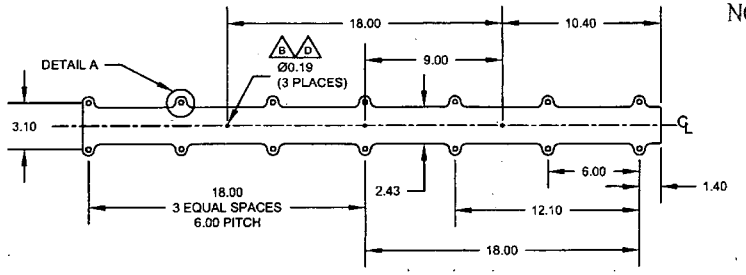
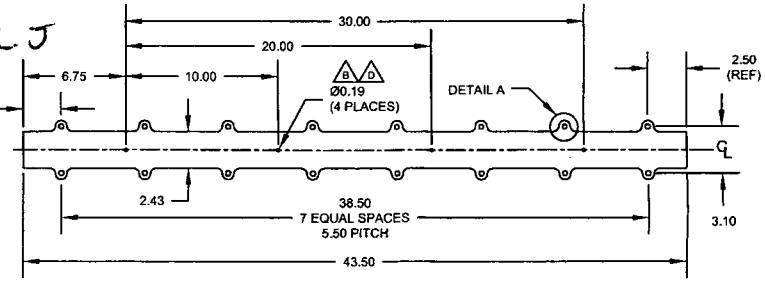
NOTE: Date & initial all entries

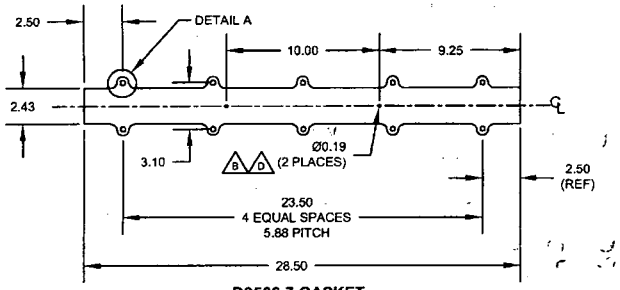
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74518 M.L.J
11/10/03



D3566-1 GASKET



D3566-5 GASKET



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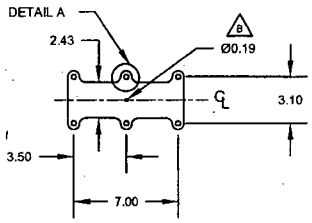

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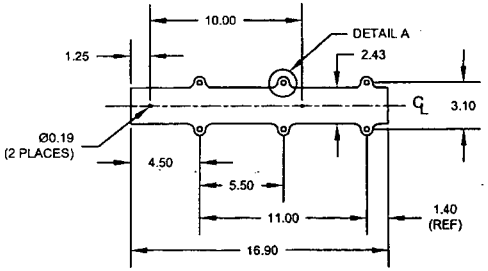
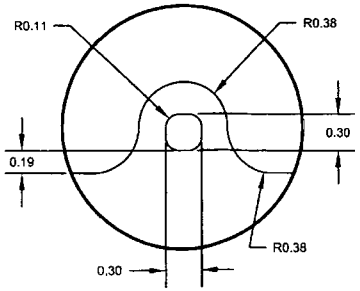


D3566-15 GASKET D

RELEASED
07.08.04



DETAIL A
SCALE 1:1

NOTES:
1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER
(REF DART SPEC M-NEO60-S.063)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: SEE TABLE IN ZONE A3
8) PARTS ARE SYMMETRIC ABOUT ℄

WEIGHTS:

D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

REV.	DESCRIPTION	BY	DATE
C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.		D3566	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GASKET	1:8
DATE	07.08.21		

Dart Aerospace Ltd

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